NOV

Work Order ID 91150

October-03-12 9:05:17 AM

91150

Item ID: D3805-045 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Wearplate Assembly Aft, Low Gear **Stop** *NS2*

Start Date: 03/10/2012 **Start Qty:** 8.00 *8* **Cust Item ID:**

Required Date: 12/11/2012 **Req'd Qty:** 8.00 *8* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLS **Date:** 12-10-03 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3805	B

100

100

Large Fab

Large Fab

0.00

Memo 0.00

(x8) 12/10/31 MAL/CC

1- On D3806-5, fill cut outs with hardcoat welding rod as per dwg D3805
2059 B Hardcoat Welding Rod
BATCH#: M123377

2-weld D3806-5 to D3805-5 together as per dwg D3805
304 S.S. Welding Rod
BATCH #: M121603

3-Transfer drill holes in bar

CUT BAR TO FINISH SIZE AFTER WELDING HARD COAT

110

110

QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds 0.00

Memo 0.00

(8) 12-10-31 DAS 09 8-89

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________________

Part No. ____________________

NCR No. ____________________

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 91150

October-03-12 9:05:17 AM

91150

Item ID:	D3805-045	**Accept**	*N900040100*
Revision ID:		**Setup Start**	*NS1*
Item Name:	Wearplate Assembly Aft, Low Gear	**Stop**	*NS2*
Start Date:	03/10/2012	**Start Qty:** 8.00	*8*
Required Date:	12/11/2012	**Req'd Qty:** 8.00	*8*
Reference:			

Cust Item ID:

Customer:

Approvals: **Process Plan:** ________ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ________ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				8	12-10-31		DAS 09
	Memo	0.00							
130 *130* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				8X	Ø		MJ 12/10/31
M122966	**Memo** START TIME: 2:00 OVEN TEMPERATURE: 320°F FINISH TIME: 2:30	0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish	0.00				8	Ø		M 12/10/31
	Memo	0.00							

DQA: ________ Date: ________________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 91150

October-03-12 9:05:17 AM

91150

Item ID: D3805-045

Revision ID:

Item Name: Wearplate Assembly Aft, Low Gear

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Start Date: 03/10/2012 **Start Qty:** 8.00 *8*

Required Date: 12/11/2012 **Req'd Qty:** 8.00 *8*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Small Fab Small Fab	**Memo** 1- Bond D3807-5 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg BATCH: M123557 (stamp: JAS 15 9-89)	0.00 0.00				8	Ø		Ae 12.11.05
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 12.11.05				8			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: FP-1 **Memo**	0.00 0.00				✓8	0		M 12/11/05

DQA: ________ Date: ________________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Work Order: ________________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Part No. ________________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
NCR No. ________________	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 91150

October-03-12 9:05:17 AM

91150

Item ID: D3805-045

Revision ID:

Item Name: Wearplate Assembly Aft, Low Gear

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Start Date: 03/10/2012 **Start Qty:** 8.00 *8*

Required Date: 12/11/2012 **Req'd Qty:** 8.00 *8*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180*	QC21- Final Inspection - Work Order Release	0.00						12/11/09	[signature]
QC Quality Control	**Memo**	0.00							

[handwritten initials] 12-11-09

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped.	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-03-12 9:05:21 AM

Work Order ID: 91150

91150

Parent Item: D3805-045

D3805-045

Parent Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 03/10/2012 **Required Date:** 12/11/2012

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-5 *D3805-5* Plate		Manufactured	No			100	Each	18.0000	1 **	8	(x8)	12/10/31	MAL

B 91206 (x8)

Location		Loc Qty	Loc Code
WA		7	
	90478	7	
WA030		11	
	75676	2	
	90479	9	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3806-5 *D3806-5* Bar		Manufactured	No			100	Each	44.0000	1 **	8	(x8)	12/10/31	MAL

B 91213 (x8)

Location		Loc Qty	Loc Code
WA		40	
	90481	10	
	90482	10	
	90483	10	
	90484	10	
WA030		4	
	46781	2	
	75941	2	

DQA: ______ Date: ______

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ______	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ______	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ______
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	______	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	______	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	______	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

October-03-12 9:05:21 AM

Work Order ID: 91150

91150

Parent Item: D3805-045

D3805-045

Parent Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 03/10/2012 **Required Date:** 12/11/2012

Start Qty: 8.00 **Required Qty:** 8.00

D3807-5 Manufactured No 150 Each 23.0000 1 8

D3807-5

Gasket

** ~~890485~~ (x8) Ae 12.11.05

Location		Loc Qty	Loc Code	
GA		23		
	74944	1		
	78132	3		
	79572	2		
	(79626)	17		8

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

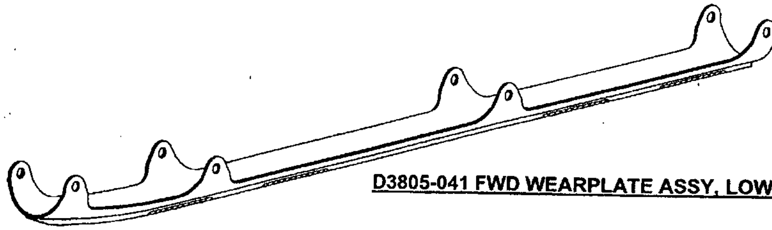
QA Closed: Date:

	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Work Order: ____________	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Part No. ____________	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
NCR No. ____________	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
	Work Order Update ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐

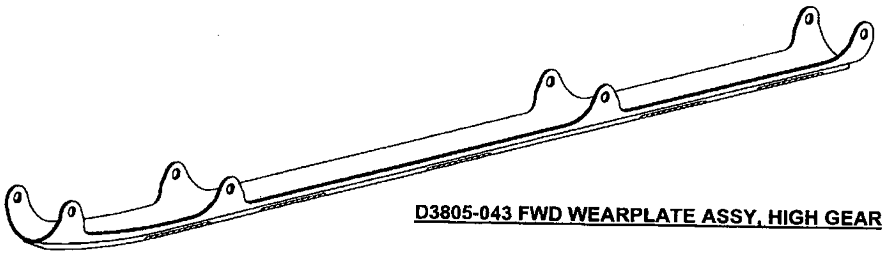
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

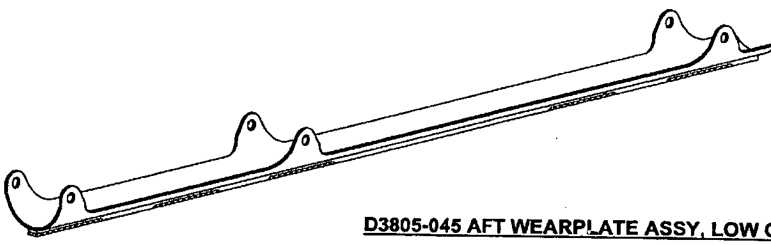
Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		



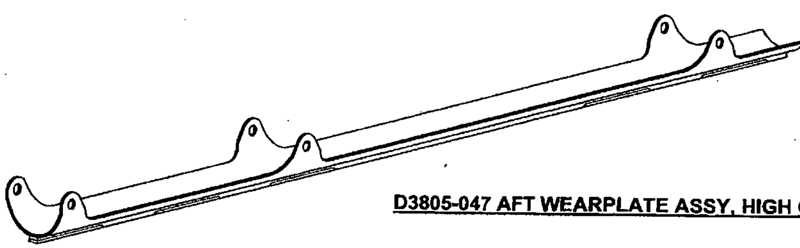
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR

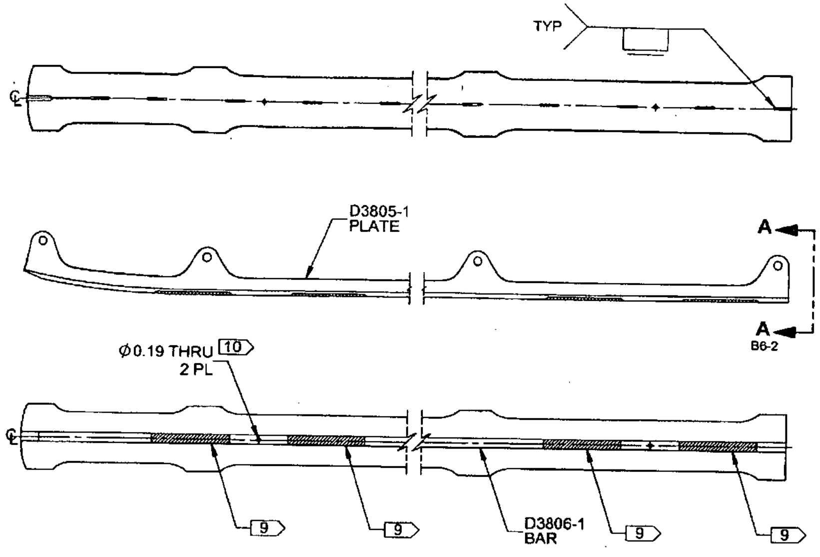


D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

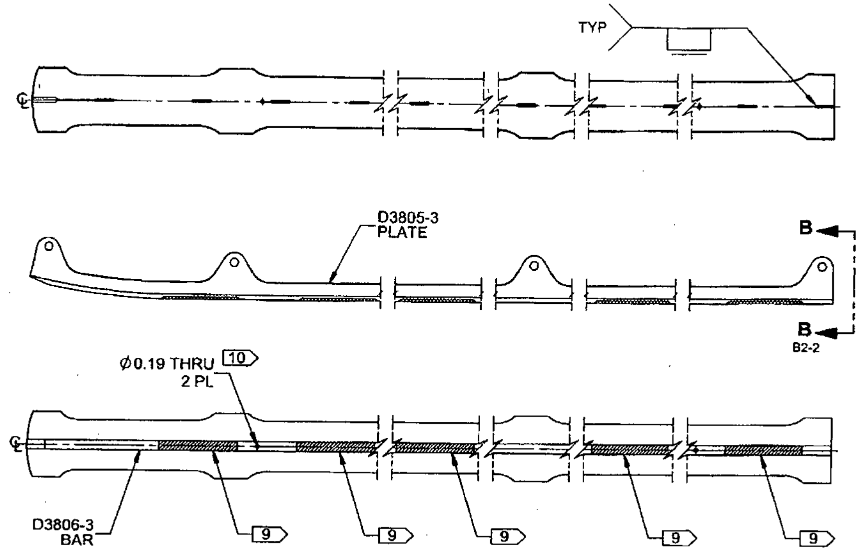
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

REV.	DESCRIPTION	BY	DATE
B	REVISED D3805-1F/-3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PAR11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21

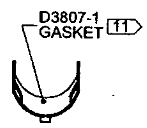
DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D3805 — REV. B — SHEET 1 OF 8
MFG. APPR.		
APPROVED		TITLE WEARPLATE ASSY — SCALE NTS
DE APPR.		
DATE	11.09.16	



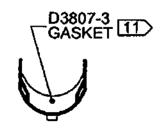
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



VIEW A-A C5-2



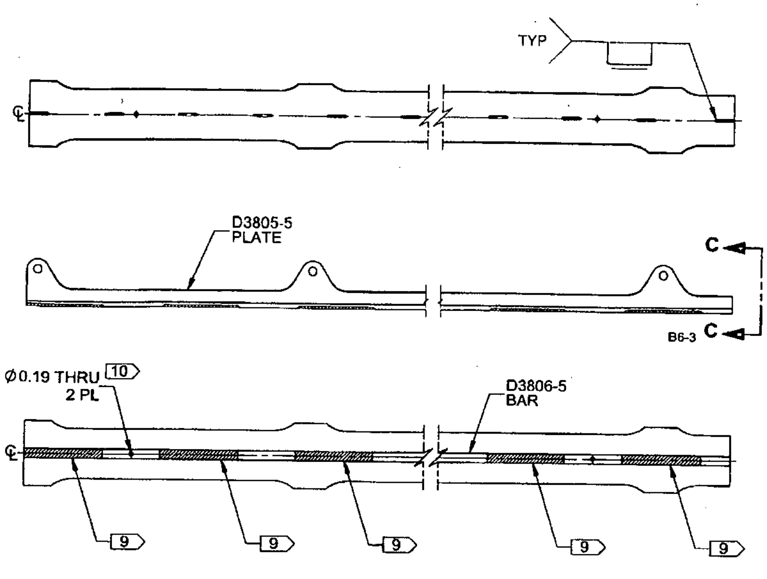
VIEW B-B C1-2

RELEASED 2011-10-03

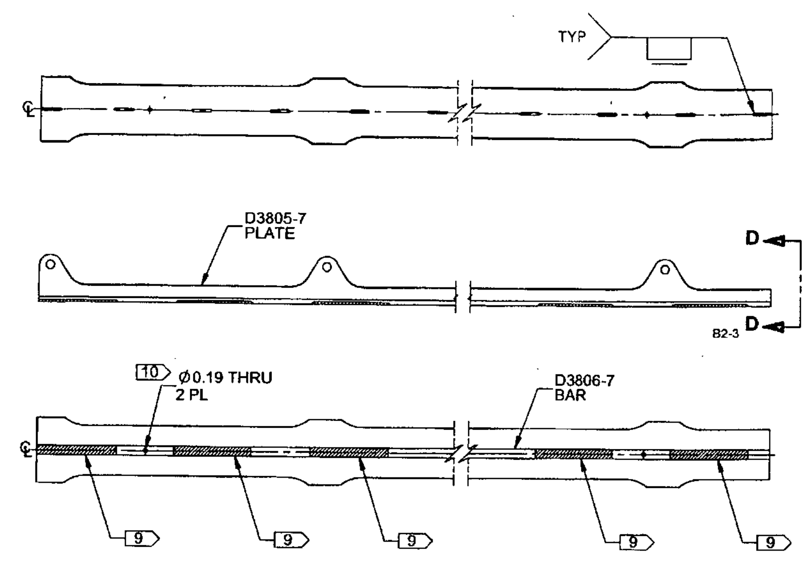
NOTES: B
1) MATERIAL: N/A
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D3805 — REV. B — SHEET 2 OF 8
MFG. APPR.		
APPROVED		TITLE WEARPLATE ASSY — SCALE NTS
DE APPR.		
DATE	11.09.16	

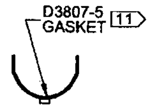
91150



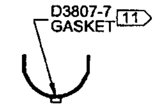
D3805-045 AFT WEARPLATE ASSY.



D3805-047 AFT WEARPLATE ASSY.



VIEW C-C C5-3



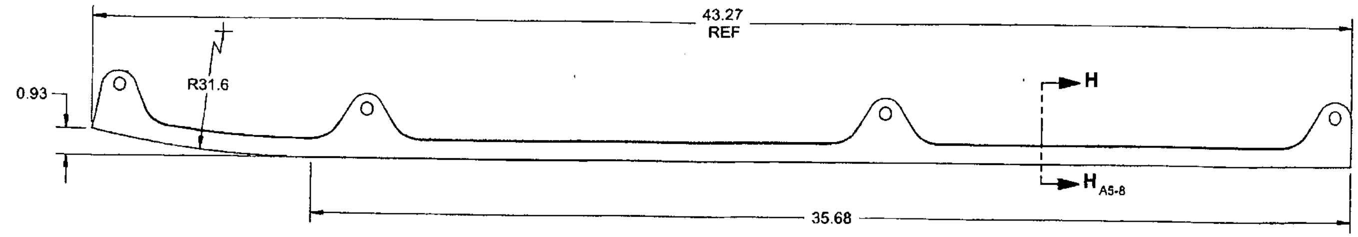
VIEW D-D C1-3

RELEASED 2011-10-03

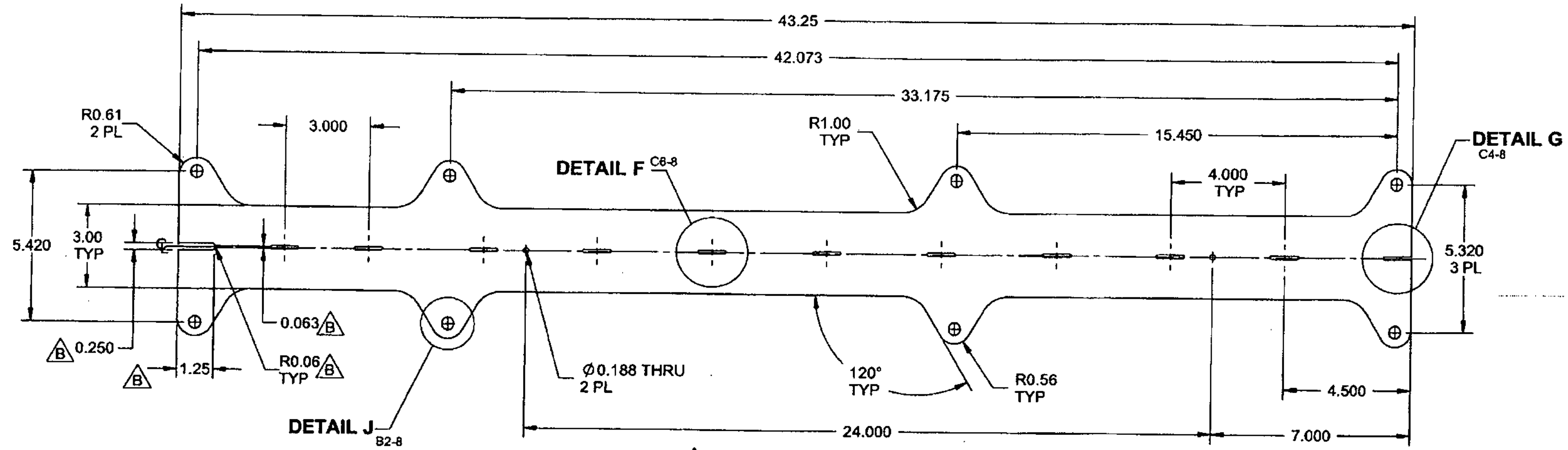
NOTES: B
1) MATERIAL: N/A
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	GP	DART AEROSPACE USA, INC. KENT, WA
DRAWN		DRAWING NO. D3805 — REV. B — SHEET 3 OF 8
CHECKED	GP	
MFG. APPR.		TITLE: WEARPLATE ASSY — SCALE: NTS
APPROVED		
DE APPR.		
DATE	11.09.16	

91150



D3805-1 PLATE
(MAKE FROM D3805-1F)



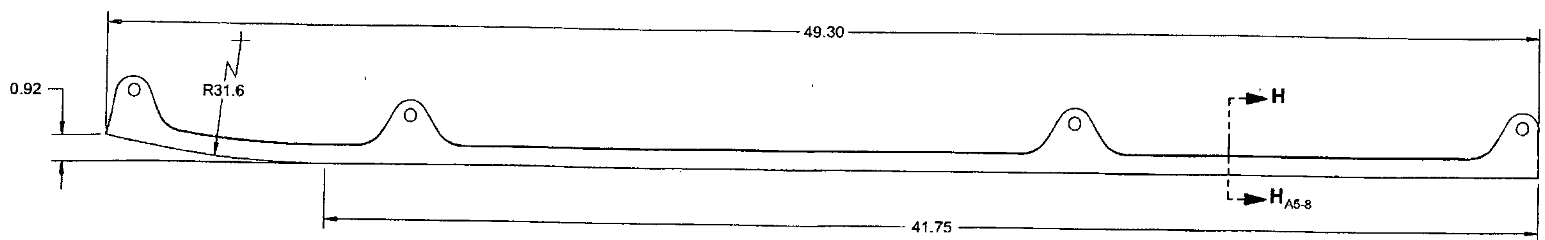
B D3805-1F PLATE

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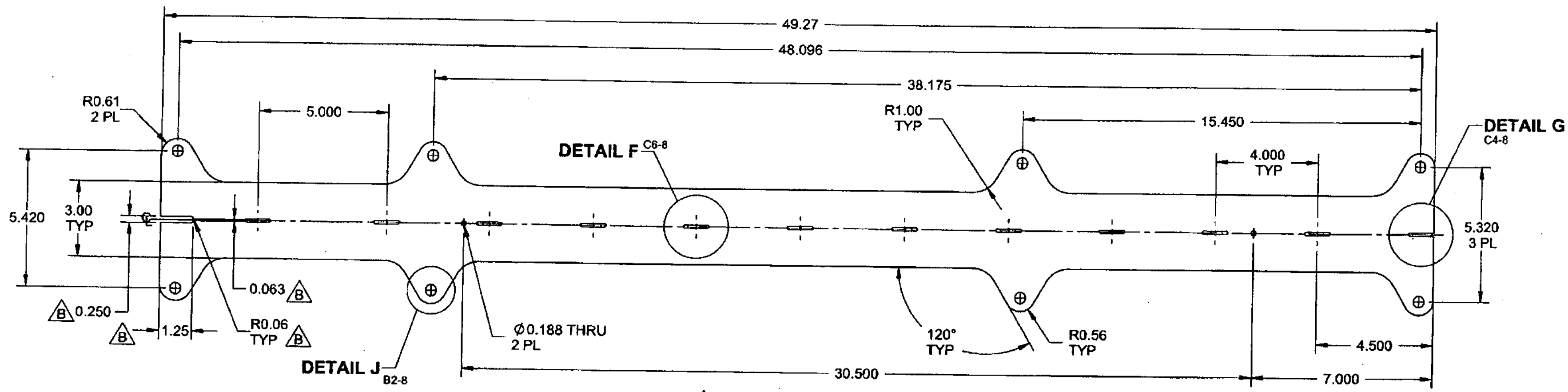
NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.11 lbs

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D3805 — REV. B — SHEET 4 OF 8
MFG. APPR.		
APPROVED		TITLE WEARPLATE ASSY — SCALE NTS
DE APPR.		
DATE	11.09.16	

91150



D3805-3 PLATE
(MAKE FROM D3805-3F)



B D3805-3F PLATE

RELEASED
2011-10-03

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.36 lbs

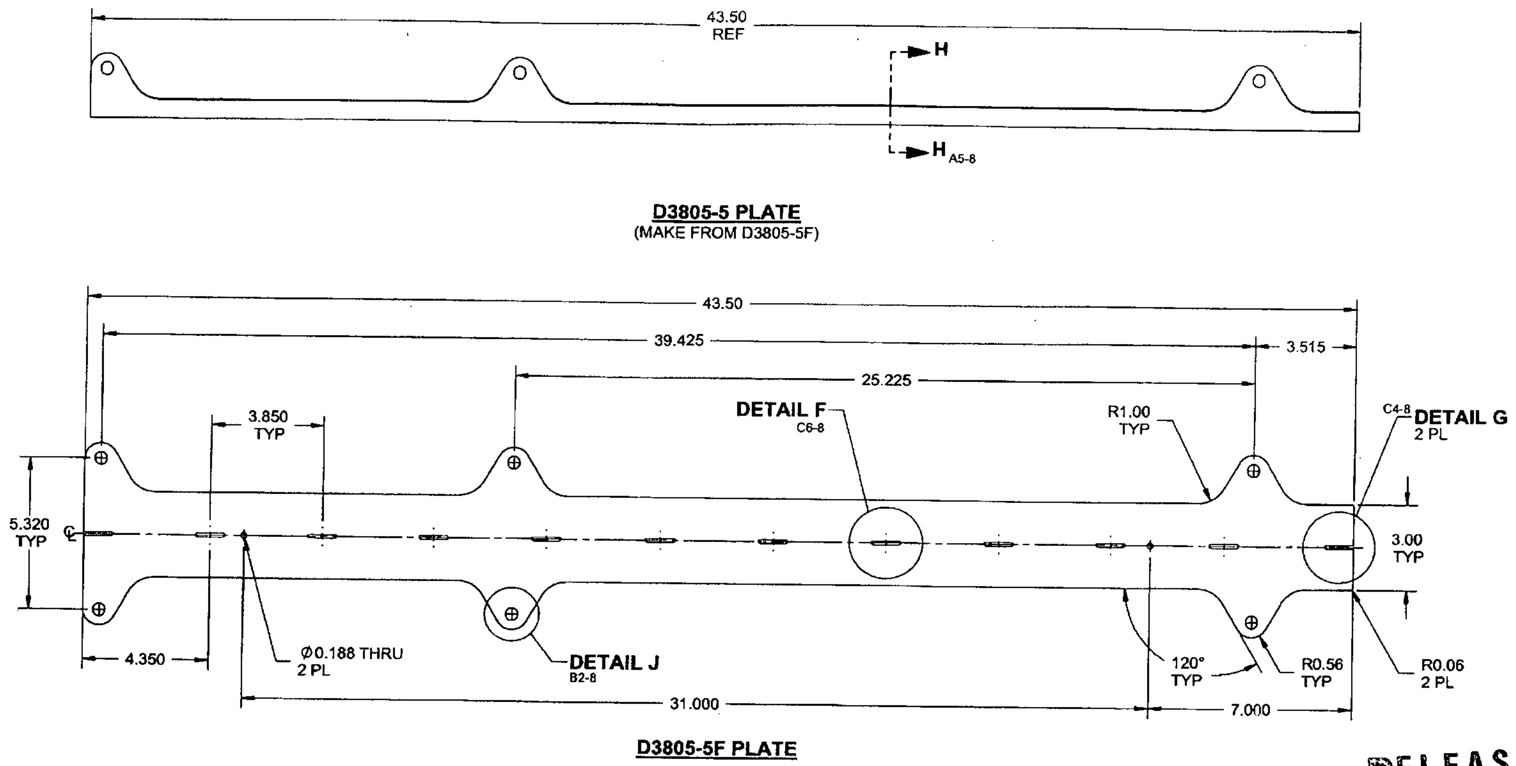
DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	11.09.16

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. D3805 — REV. B — SHEET 5 OF 8

TITLE: WEARPLATE ASSY — SCALE: NTS

9115O

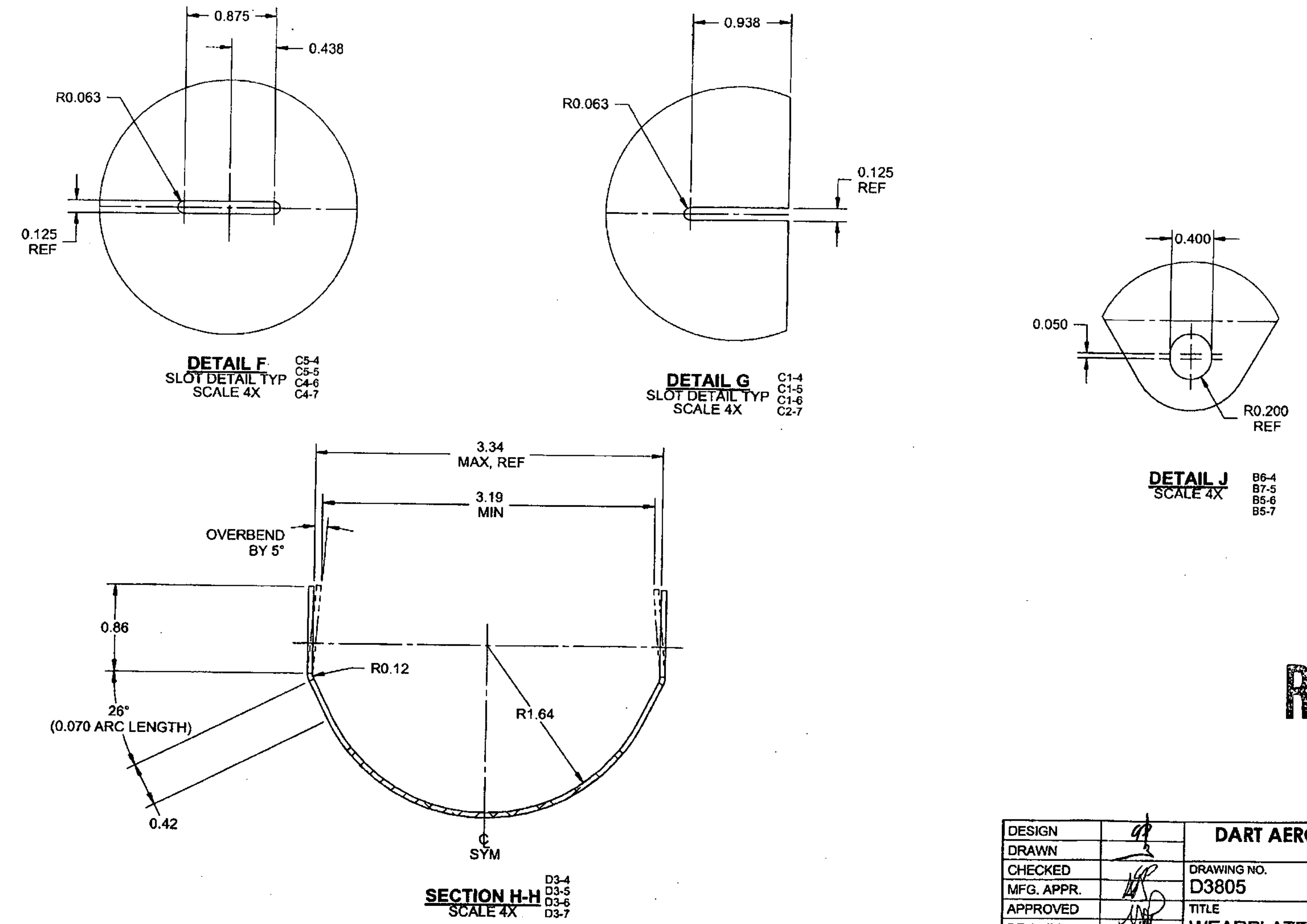


RELEASED
2011-10-03

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.06 lbs

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		DRAWING NO. D3805 — REV. B — SHEET 6 OF 8
CHECKED		
MFG. APPR.		TITLE WEARPLATE ASSY — SCALE NTS
APPROVED		
DE APPR.		
DATE 11.09.16		

91150



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2011-10-03

DESIGN		DART AEROSPACE USA, INC. KENT, WA	
DRAWN			
CHECKED		DRAWING NO. D3805	REV. B SHEET 8 OF 8
MFG. APPR.			
APPROVED		TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.			
DATE	11.09.16		